

# इंटरनेट

# मानक

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IS 6268 (1971): Accessories for Use in Shuttles for Plain Calico Looms [TXD 14: Machinery for Fabric Manufacture]



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“Knowledge is such a treasure which cannot be stolen”



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Indian Standard

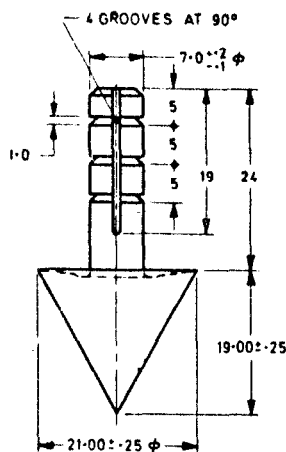
# SPECIFICATION FOR ACCESSORIES FOR USE IN SHUTTLES FOR PLAIN CALICO LOOMS

**1. Scope** — Prescribed requirements of accessories, such as tip, tongue, plate clip, back spring, reinforcement ring, pot eye, peg and rest pin for use in shuttles for plain calico looms.

## 2. Requirements

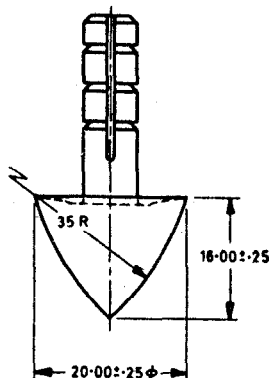
**2.1 Tips** — Made of bright steel rod conforming to the requirements of steel No. C35Mn75 or C45 of Schedule II of IS : 1570-1961 'Schedules for wrought steels for general engineering purposes'. The tips shall be any of the following three types :

- Sharp ( see Fig. 1 ).
- Half blunt ( see Fig. 2 ), and,
- Blunt ( see Fig. 3 ).

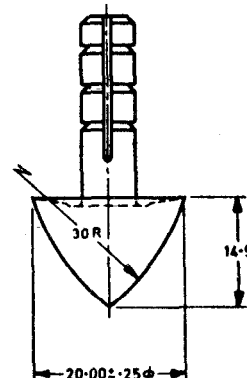


All dimensions in millimetres.

FIG. 1 A TYPICAL SHARP TIP



All dimensions in millimetres.

FIG. 2 A TYPICAL HALF  
BLUNT TIP

All dimensions in millimetres.

FIG. 3 A TYPICAL BLUNT TIP

**Note** — Dimensions of shank of Fig 2 and 3 are same as of Fig. 1.

**2.1.1** Vickers hardness of approximately two-thirds of the cone (from the tip downwards) should be ranging between 520 and 590 when tested under a load of 30 kgf according to IS : 1501-1968 'Methods for Vickers hardness test for steel (first revision)'.

**Note** — Shank should be softer than the core.

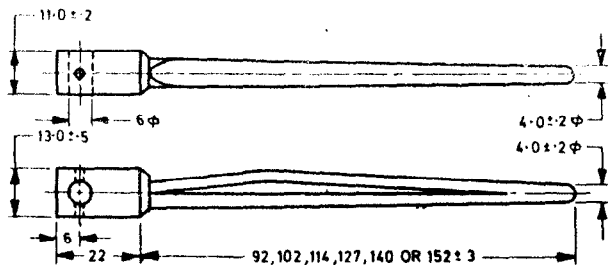
**2.2 Tongue** — Any of the following types:

- Tongue with single spring ( see Fig. 4 ),
- Tweezer plain tongue ( see Fig. 5 ), and
- Tweezer collared tongue ( see Fig. 6 ) made of mild steel wire.

Adopted 4 October 1971

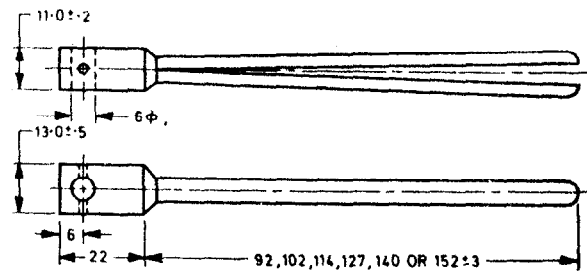
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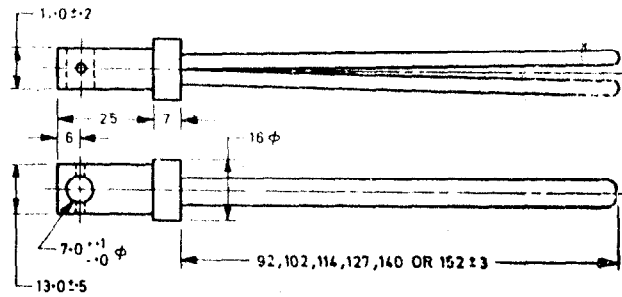
All dimensions in millimetres.

FIG. 4 A TYPICAL TONGUE WITH SINGLE SPRING



All dimensions in millimetres.

FIG. 5 A TYPICAL TWEEZER PLAIN TONGUE

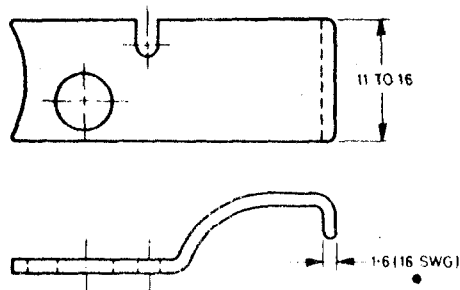


All dimensions in millimetres.

FIG. 6 A TYPICAL TWEEZER COLLARED TONGUE

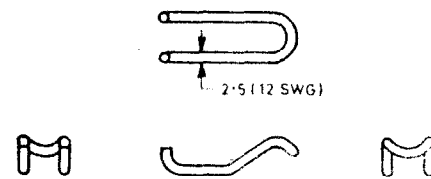
**Note** — Oil holes on both sides should be provided enabling the user to use tongue on both sides.

**2.3 Clip** — Plate clip (see Fig. 7) or wire clip (see Fig 8).



All dimensions in millimetres.

FIG. 7 A TYPICAL PLATE CLIP



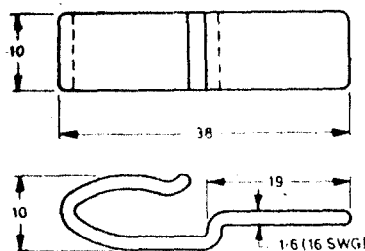
All dimensions in millimetres.

FIG. 8 A TYPICAL WIRE CLIP

**2.3.1 Plate clip** — Made of steel strip 11 to 16 mm wide and 1.60 mm ( 16 SWG ) thick.

**2.3.2 Wire clip** — Made of steel wire 2.5 mm ( 12 SWG ) thick.

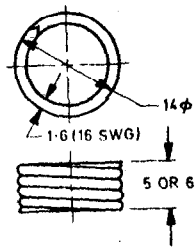
**2.4 Back Spring** — Made of flat spring steel 9.5 mm wide and 1.6 mm ( 16 SWG ) thick (see Fig. 9). The hardness of back springs shall be 40 HRC, Min when determined by the method prescribed in IS: 1586-1968 'Methods for Rockwell hardness test (B and C scales) for steel (first revision)'.



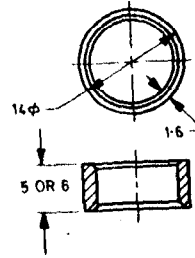
All dimensions in millimetres.

FIG. 9 A TYPICAL BACK SPRING

**2.5 Reinforcement Ring** — Wire ring (see Fig. 10) or solid ring with chamfer (see Fig. 11).



All dimensions in millimetres.  
FIG. 10 A TYPICAL WIRE RING



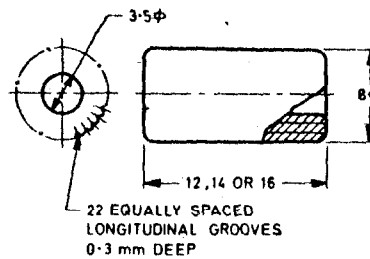
All dimensions in millimetres.  
FIG. 11 A TYPICAL SOLID RING WITH CHAMFER

**Note** — Reinforcement ring is inserted in the body of the shuttle under the tip.

**2.5.1 Wire ring** — Made of tinned steel wire 1.6 mm (16 SWG) thick.

**2.5.2 Solid ring with chamfer** — Made of mild steel tube having thickness of 1.6 mm (16 SWG).

**2.6 Pot Eye** — Made of glazed porcelain with corrugations on outside. The ends of the pot eye shall be rounded (see Fig. 12).



All dimensions in millimetres.  
FIG. 12 A TYPICAL POT EYE

**2.7 Peg or Pin**

**2.7.1 Peg** — Generally made of solid compressed wood or laminated wood.

**2.7.2 Pin** — Made of steel wire of the diameter prescribed by the buyer.

**2.8 Rest Pin** — Made of steel wire of the diameter prescribed by the buyer.

**Note** — One end of back spring (see 2.4) rests on this pin.

**3. Marking** — As far as possible, each item should be marked with the manufacturer's name, initials or trade-mark.

**3.1 ISI Certification Marking** — Details available from the Indian Standards Institution.